

Date: Friday, 11/04/2008 9:02:32 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: GASKET			
Job Number	: 38564						
Estimate Number	: 12723						
P.O. Number	:			Part Number	: D353613		
This Issue	: 11/04/2008	S.O. No.	:		Drawing Number	: D3536 REV A	
Prsht Rev.	: NC				Project Number	: N/A	
First Issue	: / /	Type	: SMALL /MED FAB		Drawing Revision	: A	
Previous Run	: 36635			Material	:		
Written By	:			Due Date	: 16/04/2008		
Checked & Approved By	: <u>JL</u> 08-4-14			Qty:	12	Um: Each	
Comment	: Est Rev:A New Issue 07-02-14 JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MNEO60S063	NEOPRENE SHEET 0.063
-----	------------	----------------------



Comment: Qty.: 0.8682 sf(s)/Unit Total : 10.4189 sf(s)

NEOPRENE SHEET 0.063

Batch: 106614 B 8-4-14

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3536

Dwg Rev: AProg Rev: AB 8-4-14

(B)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

B 8-4-14

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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C 08/04/14 (X3)

Comment: SECOND CHECK

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP
A 8-4-14 (X3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/04/2008 9:02:33 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 38564

Part Number: D353613

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



08/04/15 JH

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



08-04-14

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	38564
Description: Gasket	Part Number:	D3536-13
Inspection Dwg: D3536 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
32.90	+/-0.030	32.90	X			
29.40	+/-0.030	29.40	X			
27.40	+/-0.030	27.40	*			
23.90	+/-0.030	23.90	*			
18.98	+/-0.030	18.98	*			
14.07	+/-0.030	14.07	*			
9.15	+/-0.030	9.15	*			
5.65	+/-0.030	5.65	X			
3.90	+/-0.030	3.90	X			
8.00	+/-0.030	8.00	X			
14.00	+/-0.030	14.00	*			
20.00	+/-0.030	20.00	X			
1.89	+/-0.030	1.89	X			
0.30	+/-0.030	.315	X			
0.30	+/-0.030	.315	X			
Ø0.19	+0.005/-0.001	.199	*			

Measured by:	<u>AB</u>	Audited by:	<u> </u>	Prototype Approval:	N/A
Date:	8-4-14	Date:	58/06/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.06.13	New Issue	KJ/JLM <u> </u>	<u>EE</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

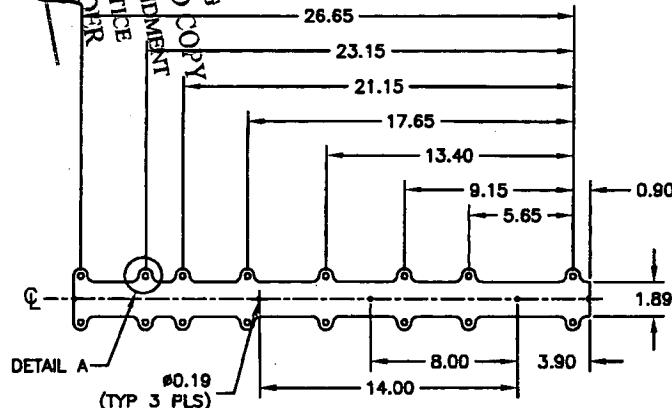
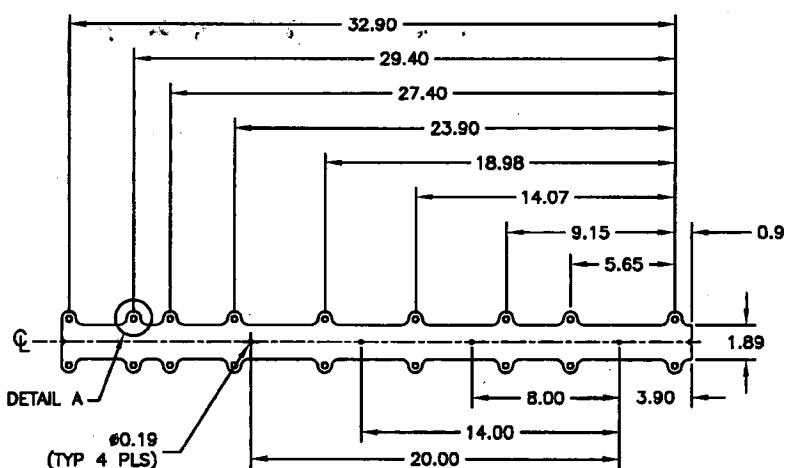
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART09.02.12-4
RELEASED

DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED PH	APPROVED PH	DRAWING NO. D3536
DATE 06.10.25		REV. A SHEET 1 OF 6
A	06.10.25	SCALE 1:10
		TITLE GASKET

**D3536-11 GASKET****D3536-13 GASKET****NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT Q
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

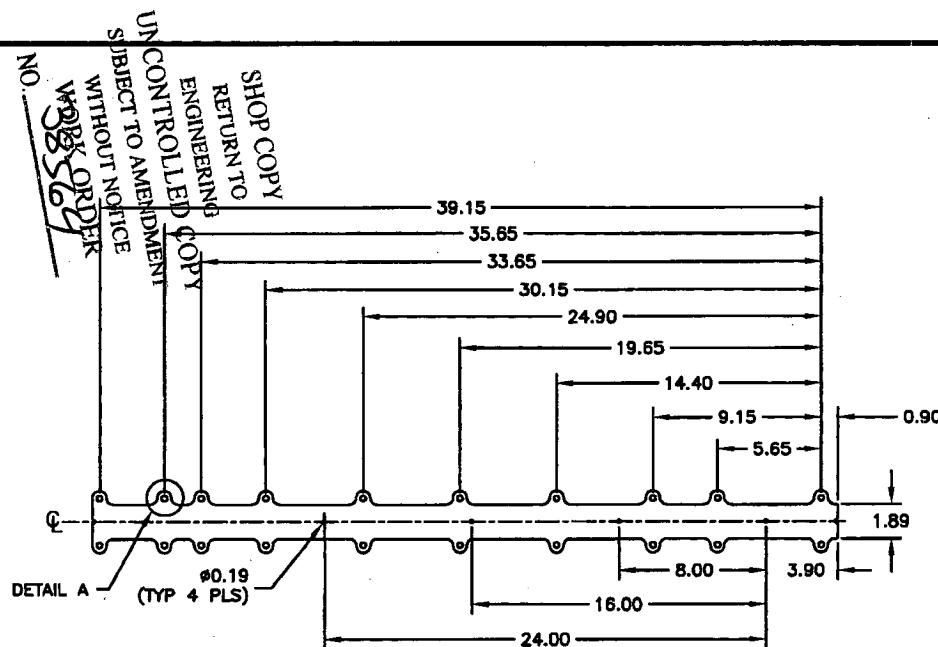
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

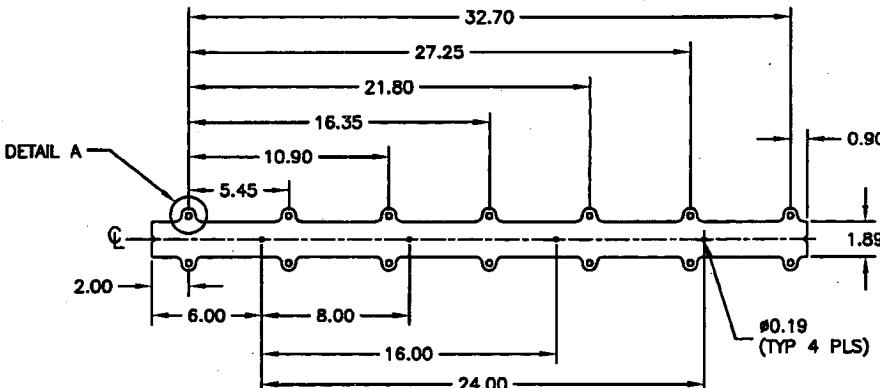
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RELEASER
07.02.12

DESIGN C B	DRAWN BY C B	DART AEROSPACE USA, INC.
CHECKED #H	APPROVED #H	DRAWING NO. PORT HADLOCK, WA
DATE 06.10.25		TITLE GASKET
		REV. A
		SHEET 2 OF 6
		SCALE 1:10



D3536-15 GASKET



D3536-21 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

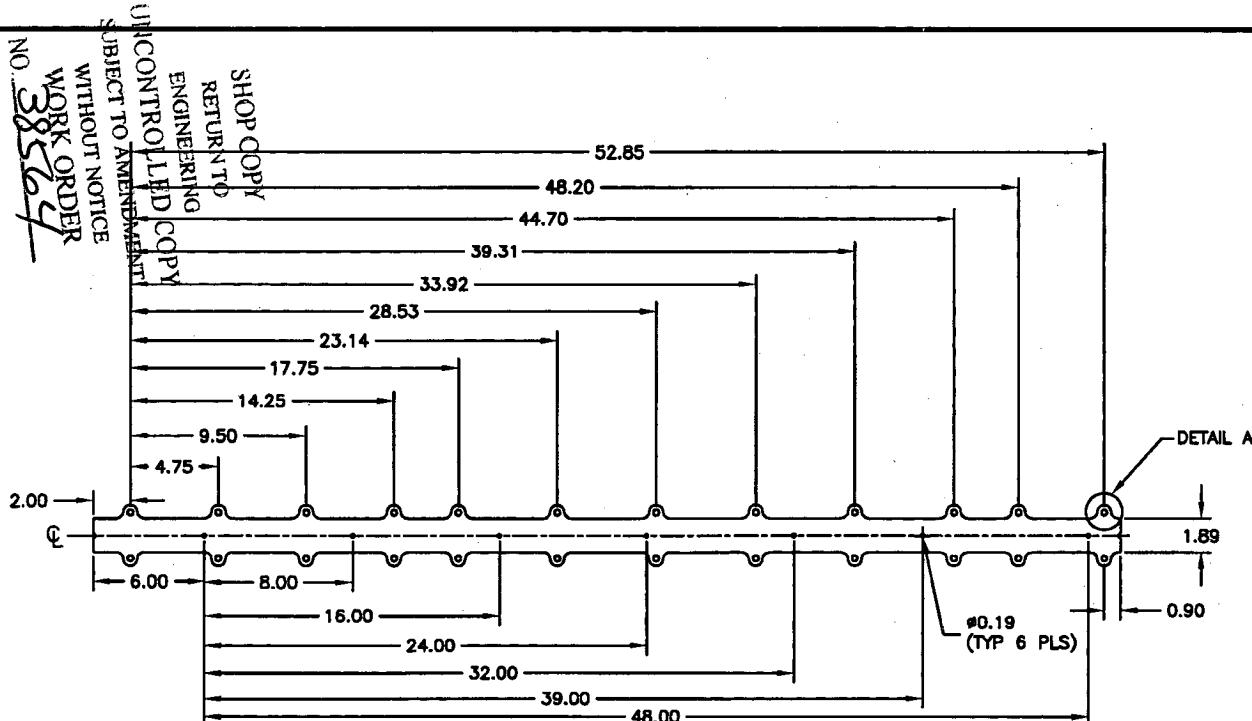
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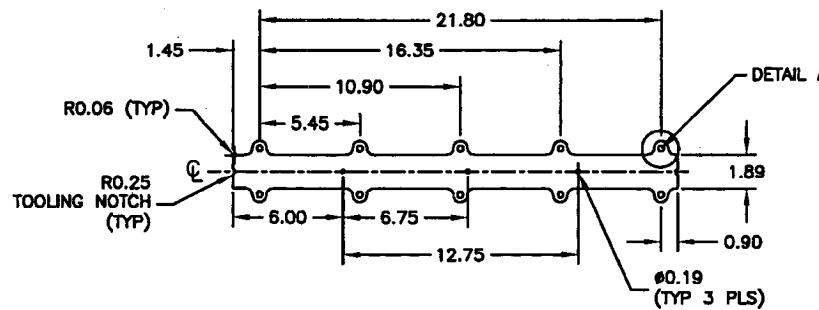
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DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED M	APPROVED M	DRAWING NO. D3536
DATE 06.10.25		TITLE GASKET
		REV. A SHEET 3 OF 6 SCALE 1:10

100% CHECKED
07.02.02



D3536-23 GASKET



D3536-25 GASKET

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

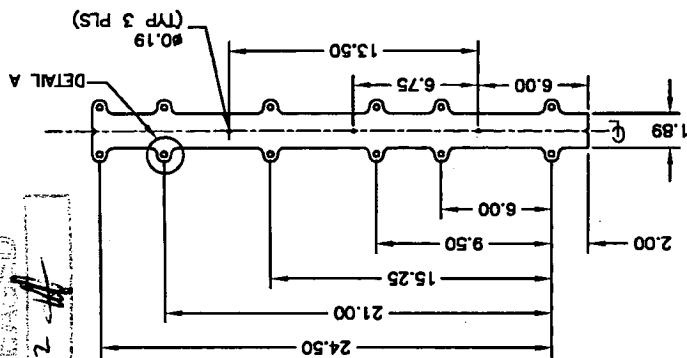
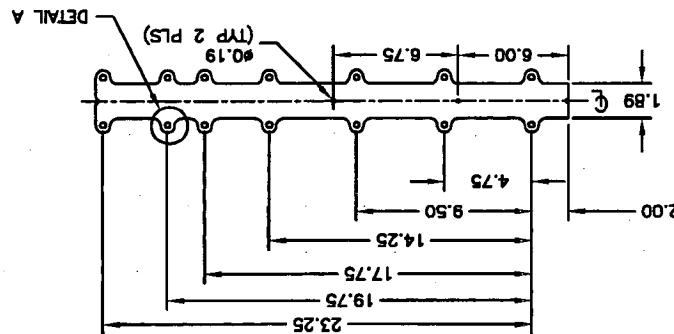
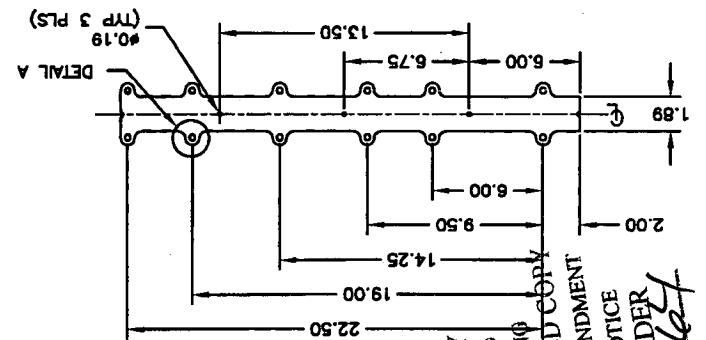
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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CHECKED MM	APPROVED MM	DRAWING NO. D3536
DATE 06.10.25		TITLE GASKET
		REV. A SHEET 4 OF 6 SCALE 1:10

07.02.12
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D3536-33 GASKET**D3536-35 GASKET****D3536-31 GASKET**

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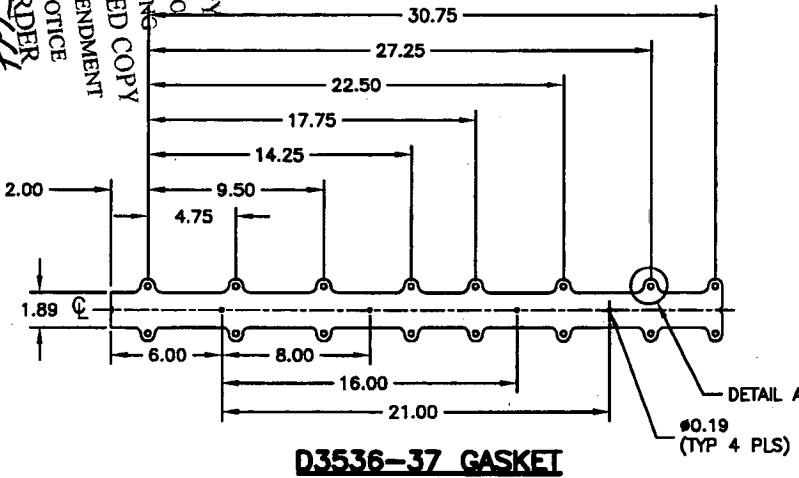
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

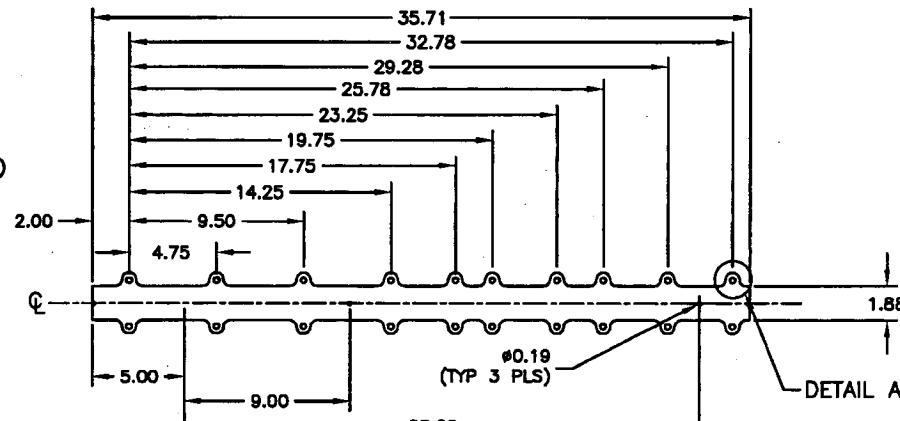
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DART07.02.12 *[Signature]*

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NO. 38564

**NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI D18 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

**D3536-39 GASKET**

DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA
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DATE 06.10.25	TITLE GASKET	REV. A SHEET 5 OF 6 SCALE 1:10

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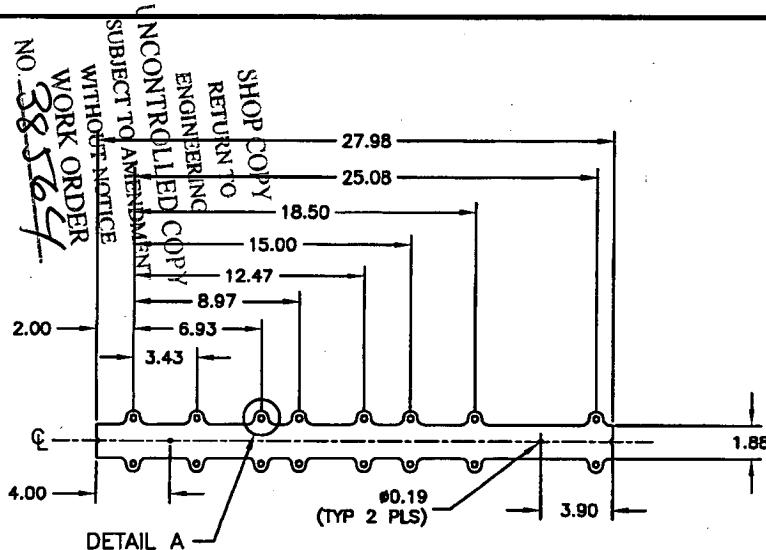
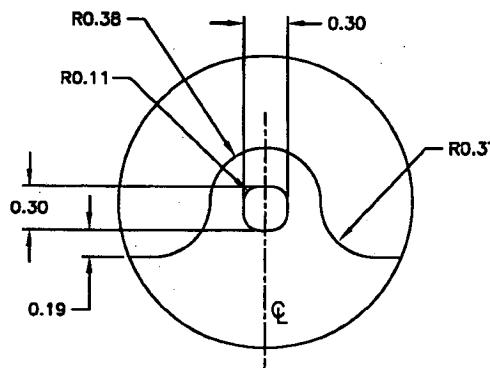
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA
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DATE 06.10.25	TITLE GASKET	REV. A SHEET 6 OF 6 SCALE 1:10

07.02.12 **MH****D3536-41 GASKET****DETAIL A**

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